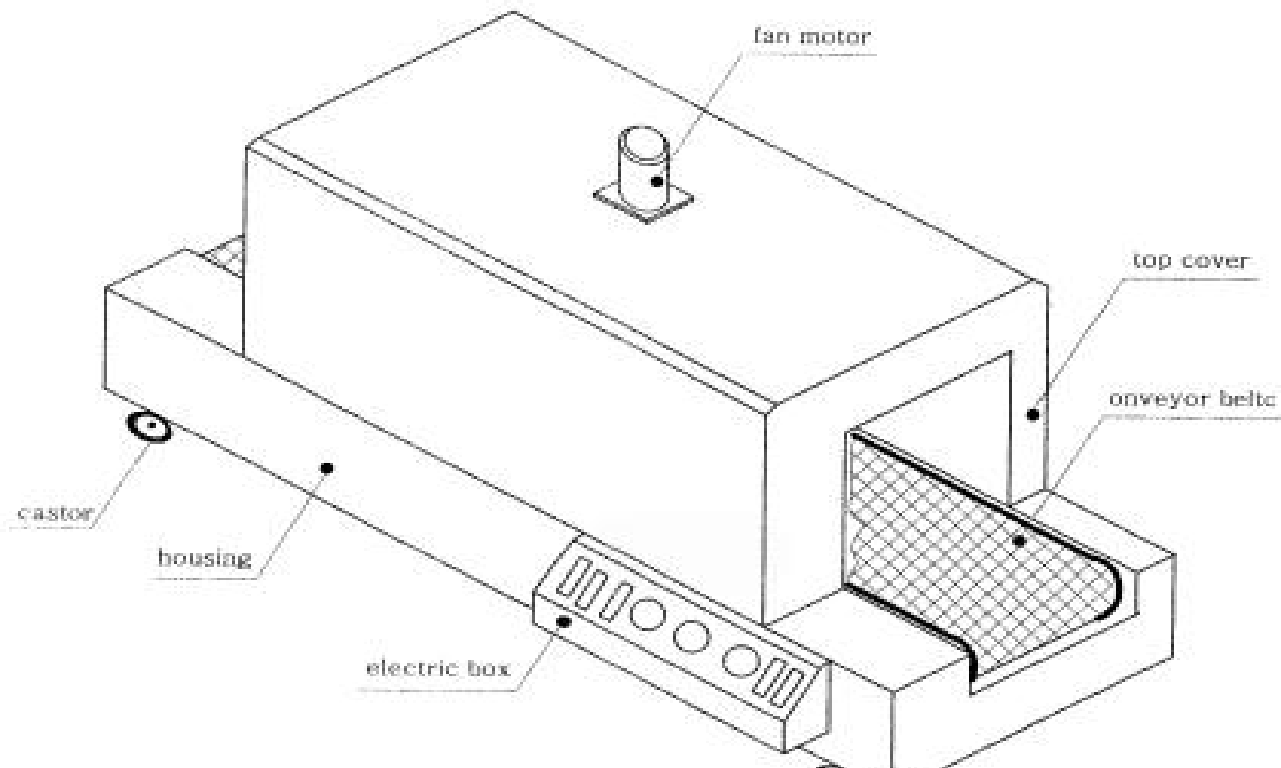


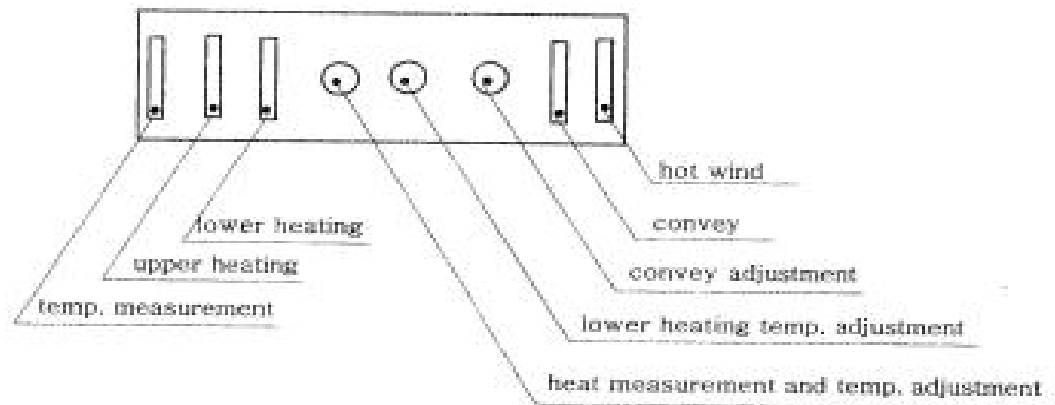
- c. Broken speed control panel, change it;
- d. Blocked transmission mechanism, check and shoot the trouble;
- e. Motor is burnt.

3. Poor shrinking effect

Improper adjustment of temp and speed.



indication function of electric box



8. Regularly clean off all the dirt and dust to keep the machine clean and prolong service life

V. Operation precautions:

1. Check whether all the accessories are completed after unpacking the machine.
2. Keep the machine even before use after installation.
3. Before operation, check whether each part is in order and ensure the machine well-grounded to avoid induction and guarantee safe operation.

well-grounded to avoid induction and guarantee safe operation.

4. After start up, observe whether heating pipes turn red to make sure whether it is in normal working state.
5. The temp. in shrinking chamber shall be below 200°C. Limitless temp. rising is strictly prohibited lest the electric circuit shall be aged early and possible short circuit shall cause damage of electric elements and shorten service life.
6. After the shrink package, turn off the heating switch. Do not stop the machine until the motor has run for 10 to 20 minutes. Otherwise, it will shorten the service life due to heat concentration.
7. Regularly oil the rotating bearing and chain to ensure normal operation.

VI. Troubleshooting

1. No heating in shrinking chamber:
 - a. Poor connection of power supply, change the switch;
 - b. Fuse throws off, displace it;
 - c. Temp. is out of control and poor connection, change solid state pressure regulator;
 - d. Heating tube throws off or loose wire connection;
2. Drive motor does not work:
 - a. Malfunction of switch of motor, change it;
 - b. The speed regulator is at zero position;

Operation Method

1. Connect 220V external power supply and turn on the power switch on the control panel and power indicator lights up.
2. Turn on motor switch on the panel.
3. Turn on heating switch on the panel.
4. Preheat the machine by adjusting the motor speed regulator and temp. setting knob of temp. controller to proper position.

For general shrinking film temperature and time, refer to the following table:

Condition Film	Common Name	Thickness (mm)	Heating Time (s)	Heating Shrinking Chamber Temp (°C)
Polyvinyl chloride	PVC	0.02-0.06	5-10	140-160
Polypropylene	PP	0.02-0.04	6-12	160-200
Polyethylene	PE	0.03-0.10	8-16	160-200
		0.12-0.20	30-60	180-200

5. Cover the goods with shrinking film and place them on the roller at the entrance

of shrinking chamber and then begin the shrinking package.

6. During actual operation, if the film is wrinkled after shrinkage, that is, the temp. is slightly low or the speed is too fast, you may slow down convey by turning speed regulator, if the film is broken after shrinkage, that is, the temp. is too high or the speed is too slow, you may speed up convey by turning speed regulator so as to get optimal shrinking package effect.
7. After the package, return the heating temp. setting knob to zero and turn off the heating switch, then keep the motor running for 10 to 20 minutes. After heat emission and temp drop, return the speed regulator to zero and finally turn off the switches of motor and power.

1. Application:

Shrinking package is one of the advanced packaging methods in current international market, which covers shrinking film over the products or packages, then heats it to make the packaging material to shrink to wrap the products or packages, to fully show the appearance of goods, increase the exhibiting ability of goods, and improve the looks and value; meanwhile, the packaged goods have the functions of sealing,

dampproof, antipollution, and impact absorption protecting against outer impact, especially for the packaged wares this kind of packaging method can protect them from being splashed when broken. Additionally, it can decrease the possibility of the goods being unpacked or thieved; the tensile force caused during the shrinkage of the shrinking film can wrap a group of goods to be packaged like a bundling rope, especially applicable for the package of group and pallet of multi goods. Therefore this product can be widely used in the shrinking package of goods such as light industry, food and drinks, candies, culture articles, arts and crafts, printing products, medical products, chemical industry, hardware and electrical elements.

II. Characteristics:

BS-400 type far infrared shrink packing machine is the latest domestic auto shrinking package machine, which adopts quartz far infrared tube to heat, power saving and efficient (saving more than 15% power); the shrinking temperature and the speed of motor are steady and adjustable in wide range; the originally-created roller auto rotation device can continuously work. Thus, this product has features such as advanced design, steady and reliable performance, high efficiency, good shrinking effect, novel structure, convenient operation and service, and is applicable for any shrinking packages with shrinking films.

III. Main technical parameters:

Model	BS400 Type	BS250 Type
Conveying speed	0-10 m/min	
Max. shrinking dimensions (width x height)	400 x 200 m/m	250 x 150 m/m
Materials	Polyethylene (PE) Polypropylene (PP) Polyvinyl chloride (PVC)	
Power supply	380V. 220V 50 HZ	
Power	4.4 KW	3 KW

Power	0.6 KW	3 KW
External dimensions (length x width x height)	1100 x 570 x 670 m/m	1080 x 500 x 450 m/m
Gross weight	75 kg	42 kg

BS-400 SERIES
FAR INFRARED SHRINK PACKING MACHINE

OPERATION MANUAL

